

Work Order ID 69215

Thursday, May 05, 2011 9:21:36 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4353-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bearpaw Assembly

Start Date: 5/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00

Customer:

Reference:

11-05-05



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4353	<i>PAI PBI</i>								

120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D4353-1 File								

B11-S-5

1

130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per FolioFB050 and Dwg
 FOLIO REV: *PAI*
 DWG REV: *PBI*

3-Deburr

Final 11-05-12 1

Work Order ID 69215

Page 2

Thursday, May 05, 2011 9:21:36 AM

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Setup Start



Revision ID: PRELIM

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Item Name: Bearpaw Assembly

Start Date: 5/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
150 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
152 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							

Jrd/11.05.12 1 ~~0~~

SL 11/05/09

Jrd/11.05.12

1 ~~0~~

Work Order ID 69215

Page 3

Thursday, May 05, 2011 9:21:36 AM

Item ID: D4353-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bearpaw Assembly

Start Date: 5/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

153

0.00



Small Fab

Memo

0.00

Small Fab

PRESS D4353-3 INSERT INTO BEARPAW

Jm/11.05.12

1 Ø

154

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

11.05.12

155

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo






0.00



Packaging


Work Order ID 69215

Page 4

Thursday, May 05, 2011 9:21:36 AM

Item ID: D4353-041 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Bearpaw Assembly
Start Date: 5/6/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/16/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Handwritten: 11.05.16

POSITIVE RECALLEFFECTIVE 11.05.16 AUTH [Signature]RELEASED [Signature] DATE 11.06.02*Scrap Eng 11.06.02*

Thursday, May 05, 2011 9:21:31 AM

Parent Item: D4353-041

Parent Item Name: Bearpaw Assembly

Start Date: 5/6/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

[illegible]

m68425 x1 Jul 11.05.22

DART AEROSPACE LTD		Work Order: 69215.
Description: <i>Bar Paw</i>	Part Number: D4353-041	
Inspection Dwg: <i>PB1</i>	Rev: <i>PBT</i>	Page 1 of 1





FIRST ARTICLE INSPECTION CHECKLIST


Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.46	+/-0.30	16.46	✓		DDOY	
15.09	+/-0.30	15.09	✓		DDOY	
10.14	+/-0.30	10.14	✓		DDOY	
7.79	+/-0.30	7.791	✓		IMV9	
5.07	+/-0.30	5.07	✓		IMV9	
2.72	+/-0.30	2.727	✓		IMV9	
7.375	7.375 +/-0.30	7.374	✓		IMV9	
3.00	+/-0.30	2.986	✓		IMV9	
R.50	+/-0.30	R.500	✓		R-6	
<i>8.44</i>	<i>+/-0.30</i>					
.30 x 45°	+/-0.30	.290 x 45°	✓		IMV9	
1.38	+/-0.30	1.365	✓		IMV9	
21.25	+/-0.30	21.25	✓		DDOY	
.63	+/-0.30	.645 ± .658	✓		IMV9	
.95	+/-0.30	.962 ± .972	✓		IMV9	
3.813	+/-0.05	3.810	✓		IMV9	
1.00	+/-0.30	1.002	✓		" "	
6.150	+/-0.10	6.146	✓		" "	
3.038	+/-0.10	3.037	✓		" "	
6.563	+/-0.10	6.561	✓		" "	
9.250	+/-0.10	9.250	✓		DDOY	
27.00	+/-0.30	27.00	✓		DDOY	
Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>		Preliminary Approval: <i>[Signature]</i>			
Date: 11.05.12	Date: 11/05/09		Date: <i>[Signature]</i>			

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

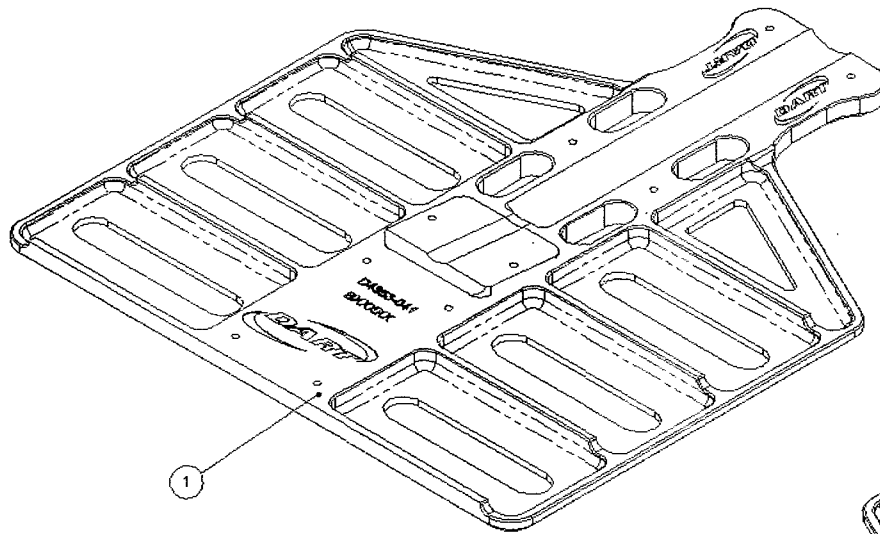
FIRST ARTICLE INSPECTION CHECKLIST

Measured by: 	Audited by: 	Preliminary Approval: 
Date: 11.05.02	Date: 11/05/09	Date: 

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

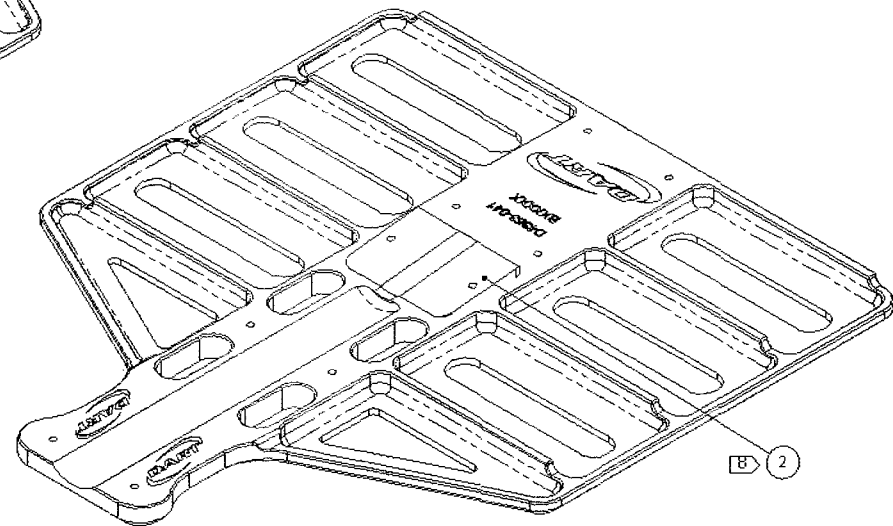
10.04.15

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



D4353-041 429 BEARPAW ASSEMBLY

PRELIMINARY B1
11.05.02 AJS

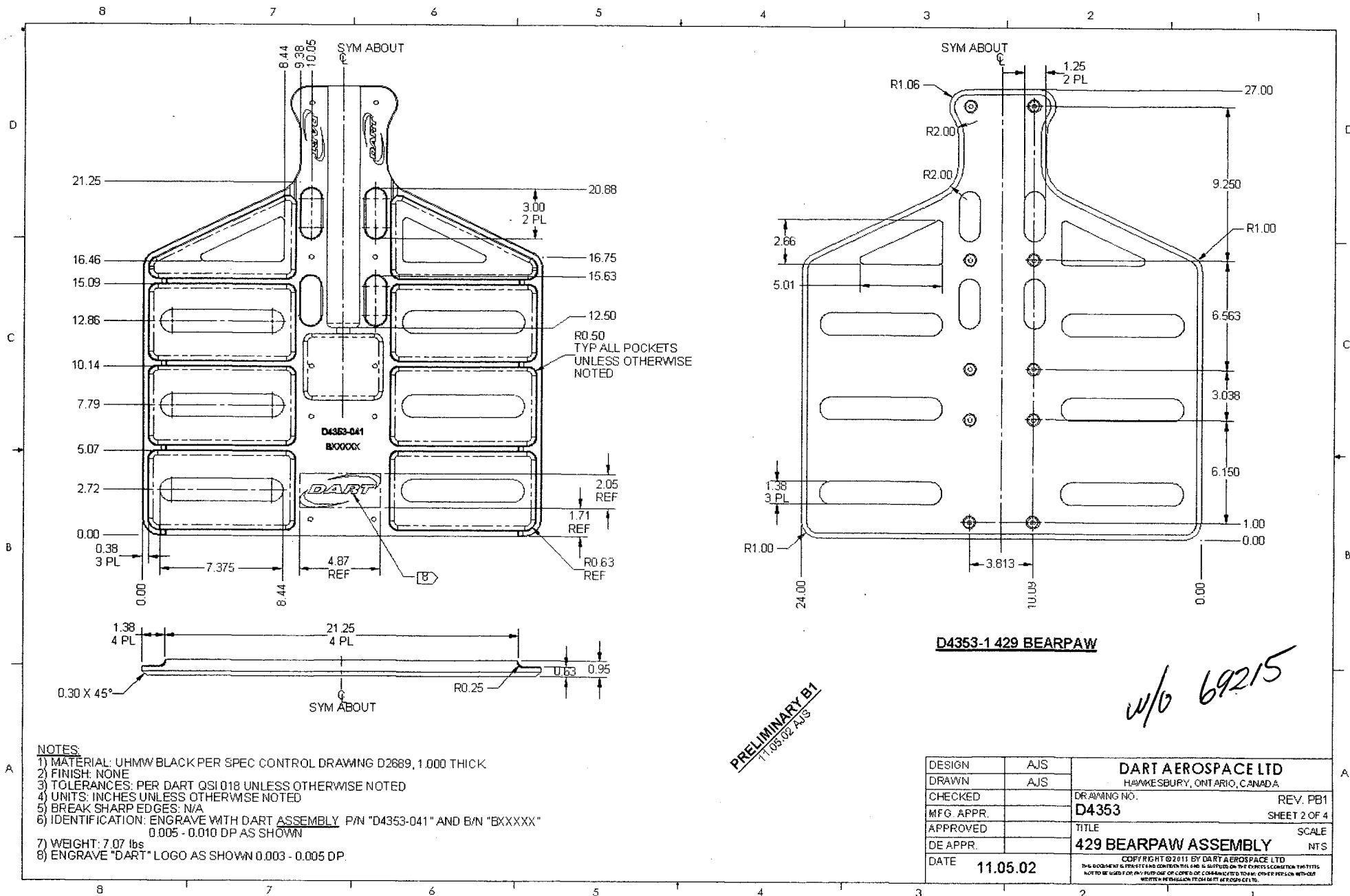


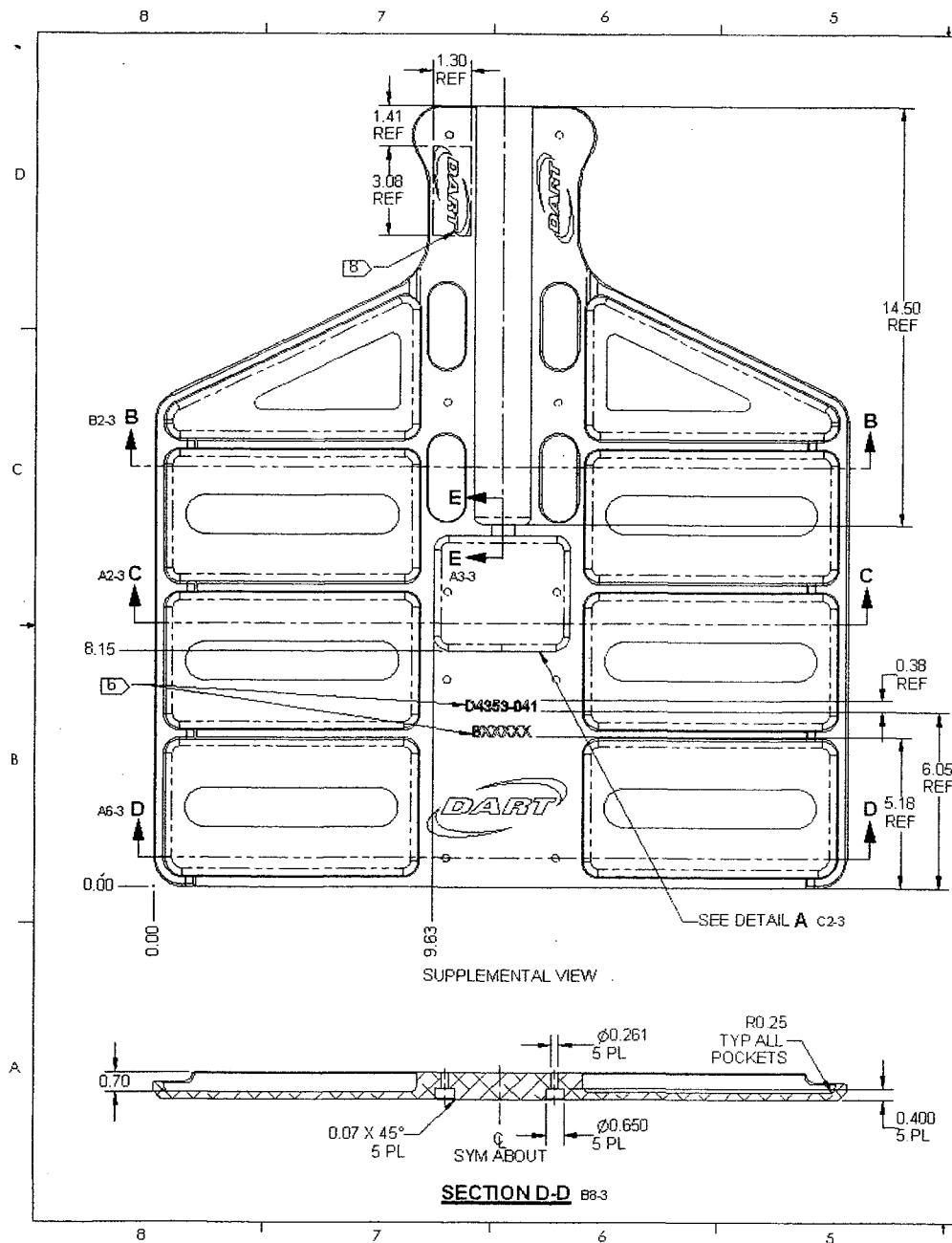
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.45 lbs
- 8) PRESS FIT

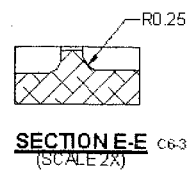
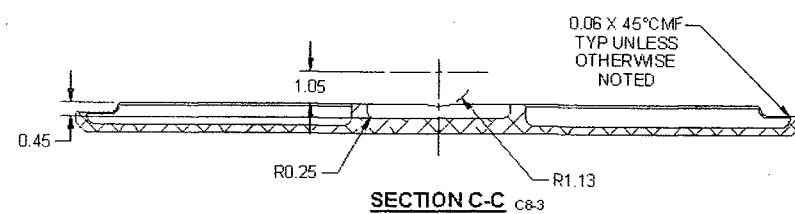
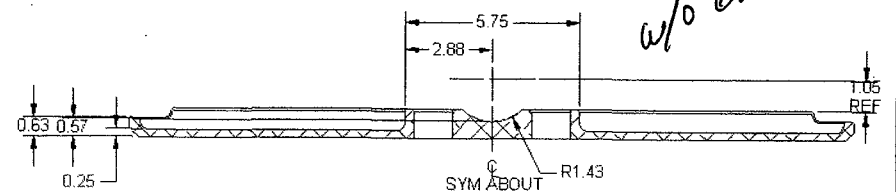
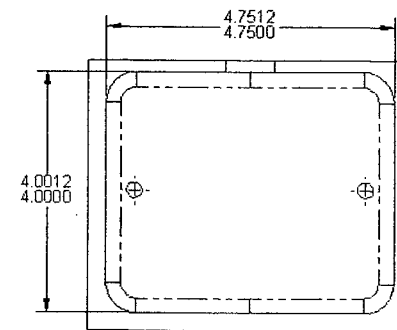
w/o 69215

PB1	PRELIMINARY B1	AJS	11.05.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4353	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		429 BEARPAW ASSEMBLY	NTS
DATE	11.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

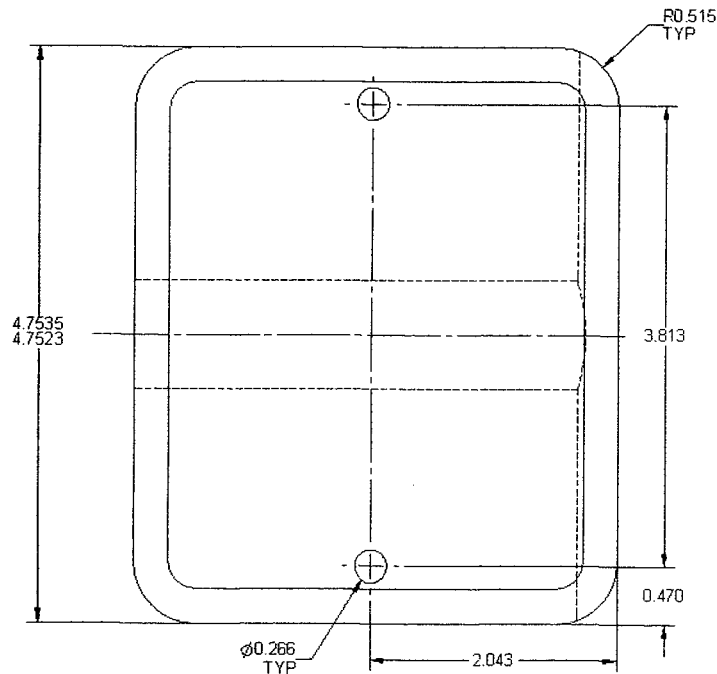
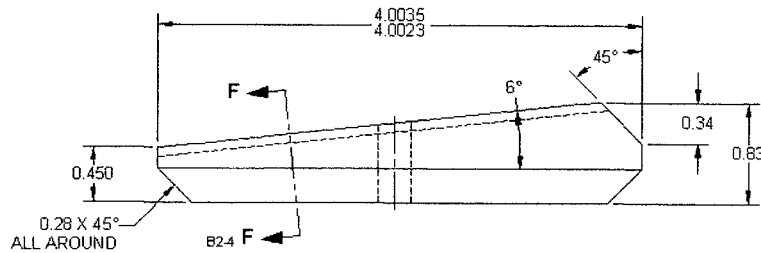




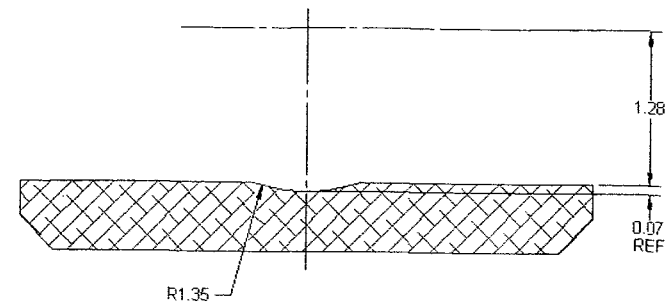
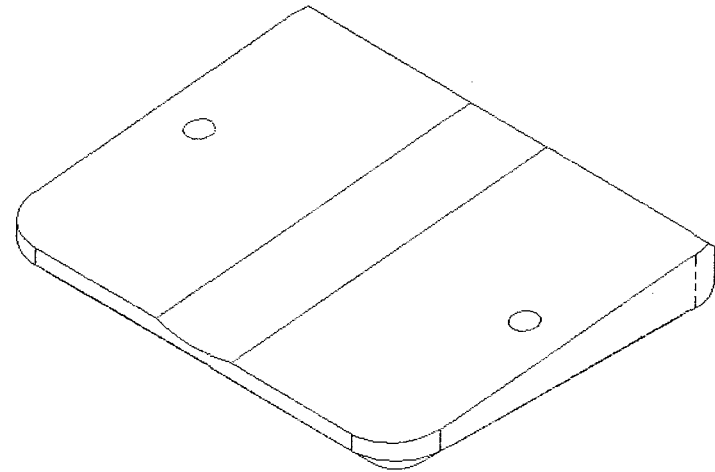
PRELIMINARY B1
11.05.02 AJS



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAMMERSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4353	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		429 BEARPAW ASSEMBLY	NTS
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D4353-3 429 BEARPAW INSERT



SECTION F-F C7.4

w/o 69215

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

PRELIMINARY B1
11.05.02 AJS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4353	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		429 BEARPAW ASSEMBLY	NTS
DATE	11.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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Receiving Report

Date: 11/4/14
 Supplier: SABRE

Batch No: M117321
 Dart P/O: 13789

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection R 11-4-14 N/A ☐
 Work Order ☐ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	A over DRE		A - P. O			Rec 11/4/14

Initials of receiver (if shipment OK) Level 12

[Signature]

Production/Admin: ☐
 Date: ☐
 Received/Costing: ☐
 Initial: ☐

Location ☐

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: April 12, 2011

YOUR PURCHASE ORDER: PO13784

SHIPPER NO: 095741

LINE ITEM #: 001

QUANTITY: 2 SHEETS

11-4-19

DESCRIPTION: TIVAR 1000 COLOURED PLATE BLACK 1 PLANED? PLANED-
FLYCUTTER, +.020 - 0

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

QUADRANT PRODUCT SUPPLIED UNDER THIS ORDER MEETS: ASTM D 4020-05 WITH
A MOLECULAR WEIGHT OF 3.0 TO 6.2 MILLION G/MOL

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL
REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE
REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS
DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT
PURCHASE ORDER.

SALES REPRESENTATIVE SIGNATURE



ALEXANDRA DAY
CUSTOMER SERVICE REPRESENTATIVE